

Date: Friday, 07/07/2006 8:59:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER KIT
 Job Number : 27583
 Estimate Number : 11799
 P.O. Number : N/A Part Number : D25251
 This Issue : 07/07/2006 S.O. No. : N/A Drawing Number : D2525 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : 15/06/2006 Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 30/06/2006 Qty: 20 Um: Each
 Checked & Approved By :
 Comment : Est. B99.11.10 Re-format added Acid etch step EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
Comment: Qty.: 0.0620 f(s)/Unit Total: 1.2400 f(s) 6061-T6 Round Bar .750" M100157 06/07/11		
2.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE 06/07/11 20		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 06/07/11 20		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S.G 06/07/11 20		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 SAP 06/07/11 20		
6.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP 06/07/11 20		

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Drawing Name: SPACER KIT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST47

AL 06/07/12

(20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/07/13

(20)

Job Completion



W 06-07-13

Date: Thursday, 6/15/2006 1:50:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER KIT
 Job Number : 27583
 Estimate Number : 11799
 P.O. Number : Part Number : D25251
 This Issue : 6/15/2006 S.O. No. : Drawing Number : D2525 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : Material :
 Written By : Due Date : 6/30/2006 Qty: 20 Um: Each
 Checked & Approved By : *06.06.15*
 Comment : Est. B90.11.10 Re-format added Acid etch stepEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



MATERIAL: 6061-T6, Ø.750"



Comment: PURCHASING

Issue P/O:

~~Make as per Dwg D2525~~

Material release note required

*(.062 Feet)**Batch:*

2.0 ~~D2525TP~~



Conventional Lathe.

~~Spacer Kit~~

Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

~~Spacer Kit~~

3.0 ~~PACKAGING 1~~ *QC2* PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 ~~QC8~~ DIMENSIONAL CHECK

QC8

Comment: DIMENSIONAL CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27583

Part Number: D25251

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0
QC3

QC3



Inspect Chemical Conversion

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/07/13

NOTE: Date & initial all entries

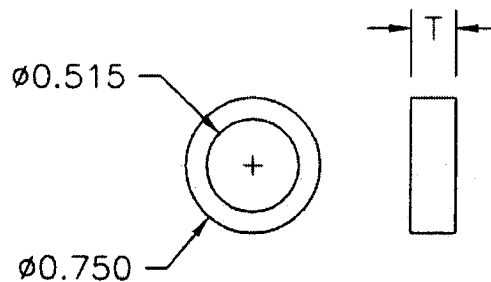
QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27583

